

shp Dec 5

Work Order ID 74931

74931

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Thursday, October 13, 2011 1:11:29 PM

Item ID: D2282-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: T Assembly
 Start Date: 10/13/2011 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 10/19/2011 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: / Date: 11-10-13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Weld as per D2282-041 'T' Handle Assembly								
	Grind chamfers and ensure full penetration as per dwg D2282								
	*****brush weld right after welding, to take color off *****								
	A/RER316L SS Filling Rod <u>11/18/16</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Small Fab	0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Tumble								

TOTAL
50X

PC 11.11.08 (16x)

BE
11.11.08

11/10/25 (34x)

50 0

11-11-10 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74931

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Thursday, October 13, 2011 1:11:29 PM

Item ID: D2282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: T Assembly
 Start Date: 10/13/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 10/19/2011 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				count (x8)			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: ST ^{GP} SA Memo	0.00 0.00							Sp 11-11-14
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/11/14 MP 11-11-14

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Picklist Print

Thursday, October 13, 2011 1:11:33 PM

Page 1

Work Order ID: 74931

74931

Parent Item: D2282-041

D2282-041

Parent Item Name: T Assembly

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3		Manufactured	No			100	Each	28.0000	1	50			
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D2282-3

Tube

**

Location

Loc Qty

Loc Code

WA019

67537

28

28

100

Each

28.0000

1

38

50

**

D2282-5

Manufactured No

D2282-5

Tube

Location

Loc Qty

Loc Code

WA020

67538

28

28

34

B 74962 → 16

W/O:		WORK ORDER CHANGES					
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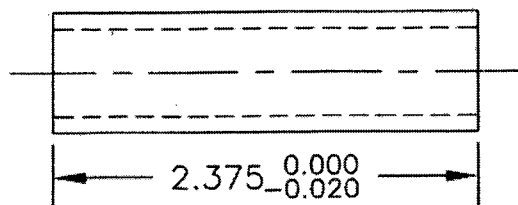
NOTE: Date & initial all entries



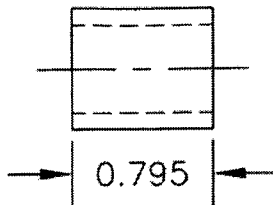
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

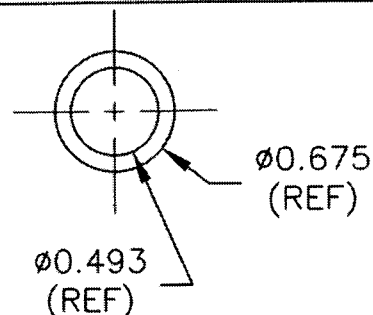
05/09/16



D2282-3

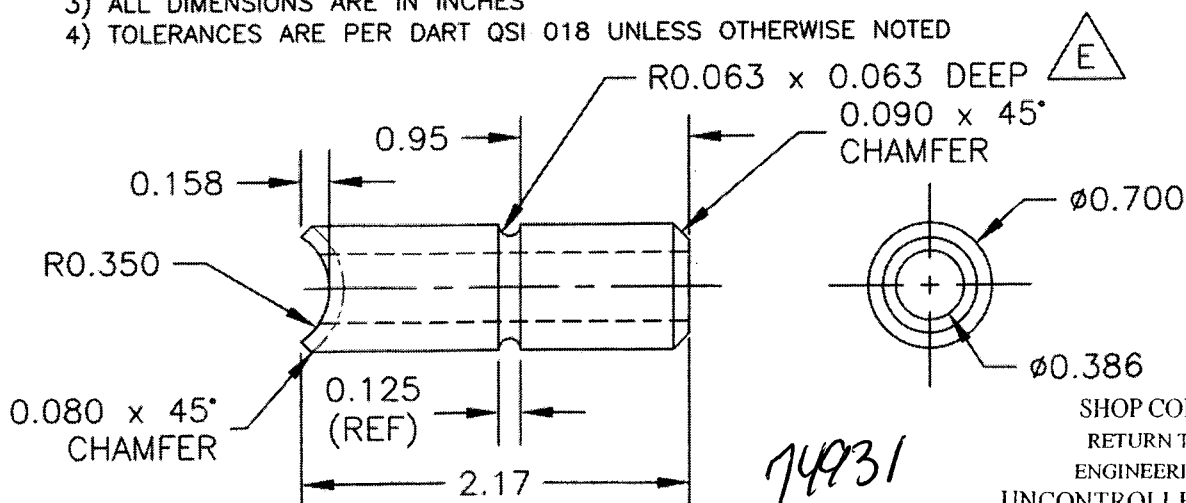


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~79764~~



M.C.J

11/10/11

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Dart Aerospace Ltd

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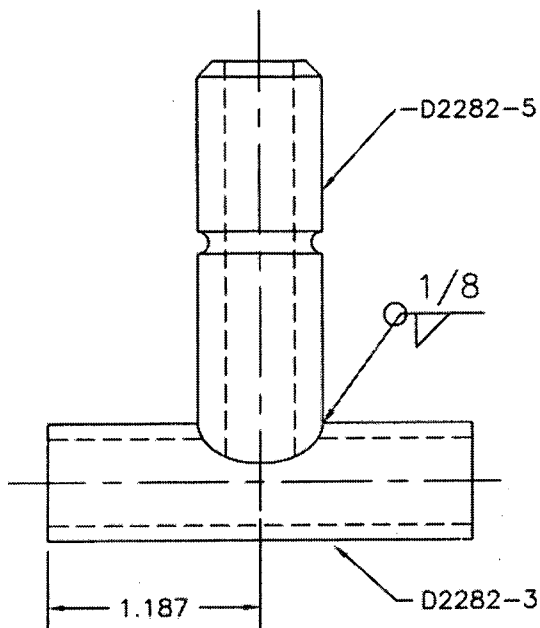
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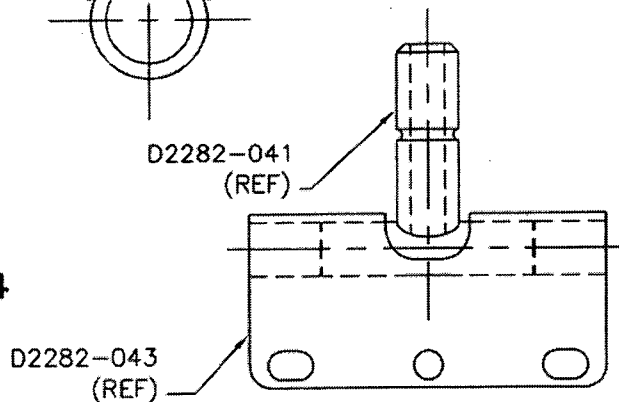
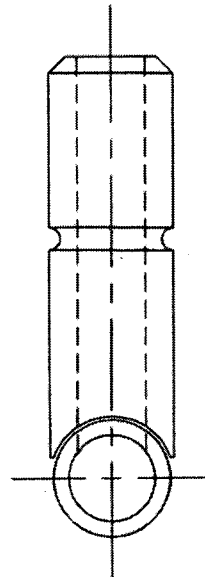
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DART

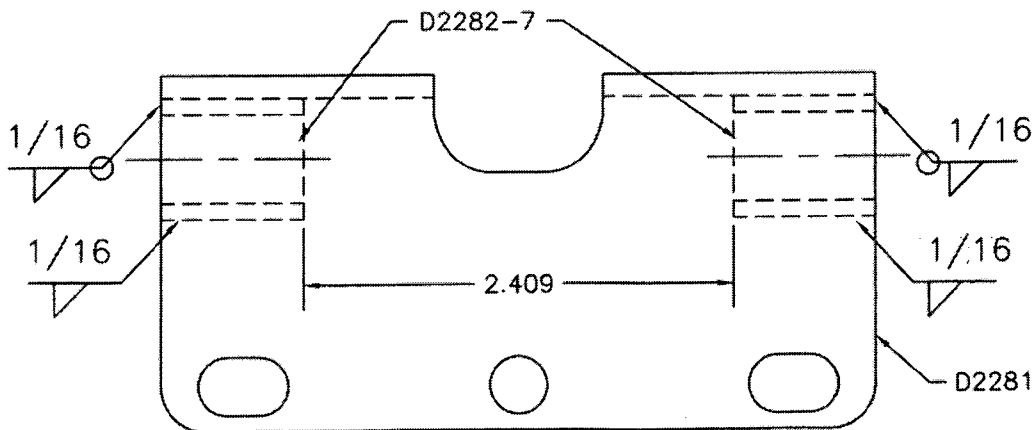
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CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

RELEASED
[Signature]
05/09/16

7493

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